

Work Order ID 71634

Thursday, July 07, 2011 11:22:22 AM



Page 1

Item ID: D3255-041

Accept



Setup Start



Revision ID:

Item Name: Access Panel Assembly

Stop



Start Date: 7/7/2011 Start Qty: 4.00 ³

Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 4.00 ³

Customer:



Reference:

Approvals: Process Plan: MF Date: 11-07-07

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3255	Rev B

100 0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Weld as per Dwg D3255 ***purge weld*** A/R SS ROD
Batch: M115778 2-Grind Welds Flush

11.07.11 (3)

110 0.00



QC10- Inspect visual per QSI004- ground welds

QC

Memo

0.00

Quality Control

8/12/12

(x3)

120 0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

8/12/12

(x3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

[illegible]

Thursday, July 07, 2011 11:22:22 AM

Accept

[illegible]**Setup Start**

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Stop

[illegible]

1. The first step is to identify the problem or question that needs to be addressed. This involves understanding the context and the specific requirements of the task.

2. Next, it is important to gather relevant information and resources. This can include researching existing solutions, consulting with experts, and collecting data.

3. Once the information is gathered, the next step is to analyze it and identify the key factors that influence the outcome. This often involves breaking down the problem into smaller, more manageable parts.

4. After analysis, a plan should be developed that outlines the steps to be taken to solve the problem. This plan should be flexible enough to allow for adjustments as more information is gained.

5. The final step is to implement the plan and monitor the progress. It is important to stay organized and keep track of the results to ensure that the problem is being solved effectively.

Cust Item ID:

Customer:

Run Start

[illegible]

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

Powdercoat

Powder Coating

Memo

START TIME:

☐ FINISH TIME:

50.00

□OVEN TEMPERATURE:

140

QC3- Inspect Part Finish

0.00

[illegible]

QC

Quality Control

Memo

0.00

150

0.00

[illegible]

Small Fab

Small Fab

Small Fab

Memo

0.00

1-Bond D3255-5 gasaket to d3255-041 using Dow corning adhesive as per Dwg
D3255□A/R 736 DOW CORNING ADHESIVE
Batch: M116664

Sp 1167/18

3x ~~0~~ m-11/07/12

3 ϕ BR 11-7-12

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Work Order ID 71634

Thursday, July 07, 2011 11:22:22 AM



Page 3

Item ID: D3255-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Access Panel Assembly

Start Date: 7/7/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 u/02/18



170

Identify as per dwg & Stock Location: 182

0.00



Packaging

Memo

0.00

Packaging

Pcu/7/18 (3)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

u/7/18 DJ

11-07-18 (3)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Thursday, July 07, 2011 11:22:19 AM

Page 1

Work Order ID: 71634

Parent Item: D3255-041

Parent Item Name: Access Panel Assembly







Start Date: 7/7/2011

Required Date: 7/21/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:C Removed Manufacturing of D3255-1/-2/-3 06-08-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3255-1  Panel		Manufactured	No			100	Each	3.0000	1			<i>11/07/11</i>	
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				WA			3						
				<i>68782</i>			3						
D3255-5  Gasket		Manufactured	No			100	Each	8.0000	1			<i>11/07/11</i>	
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				GA			8						
				68783			8						
D3255-3  Cap		Manufactured	No			150	Each	11.0000	1			<i>11/07/11</i>	
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				WA021			11						
				<i>66812</i>			11						

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

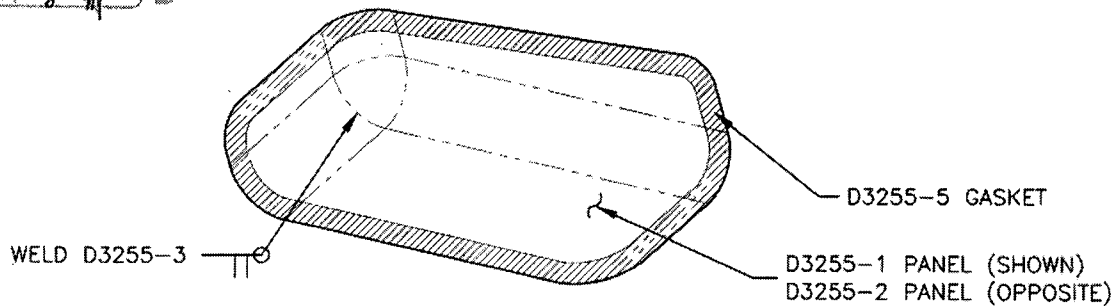
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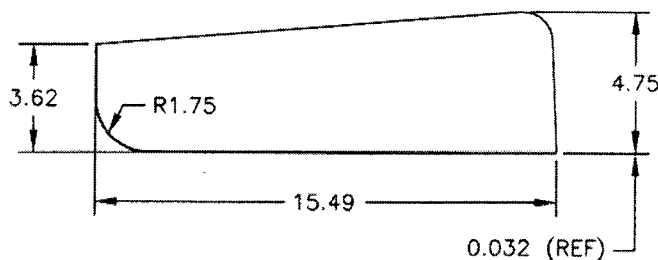
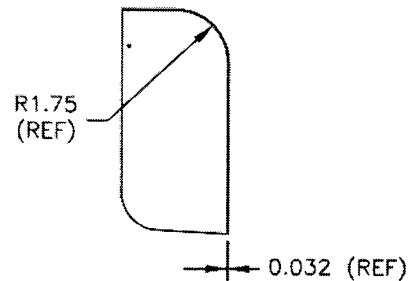
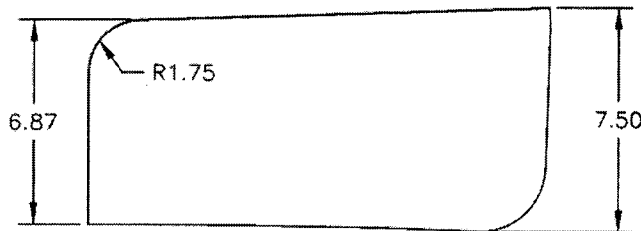


DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 4P	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6
A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED Ø0.098	

RELEASED
05-01-18 #



D3255-041 ACCESS PANEL (SHOWN)
D3255-042 ACCESS PANEL (OPPOSITE)



D3255-1 BEND DETAIL
D3255-2 OPPOSITE

D3255-041/-042 NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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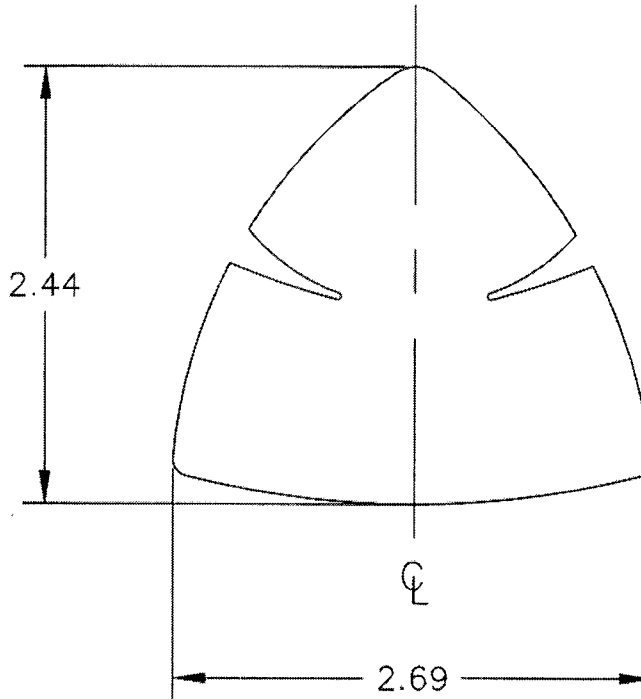
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NOTE: Date & initial all entries



DESIGN DT	DRAWN BY DT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 2 OF 4
DATE 04.12.06		TITLE TITLE	SCALE 1:1

RELEASED
05-01-18 [Signature]



D3255-3 CAP
FORM TO FIT D3155-1/-2

71634

D3255-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

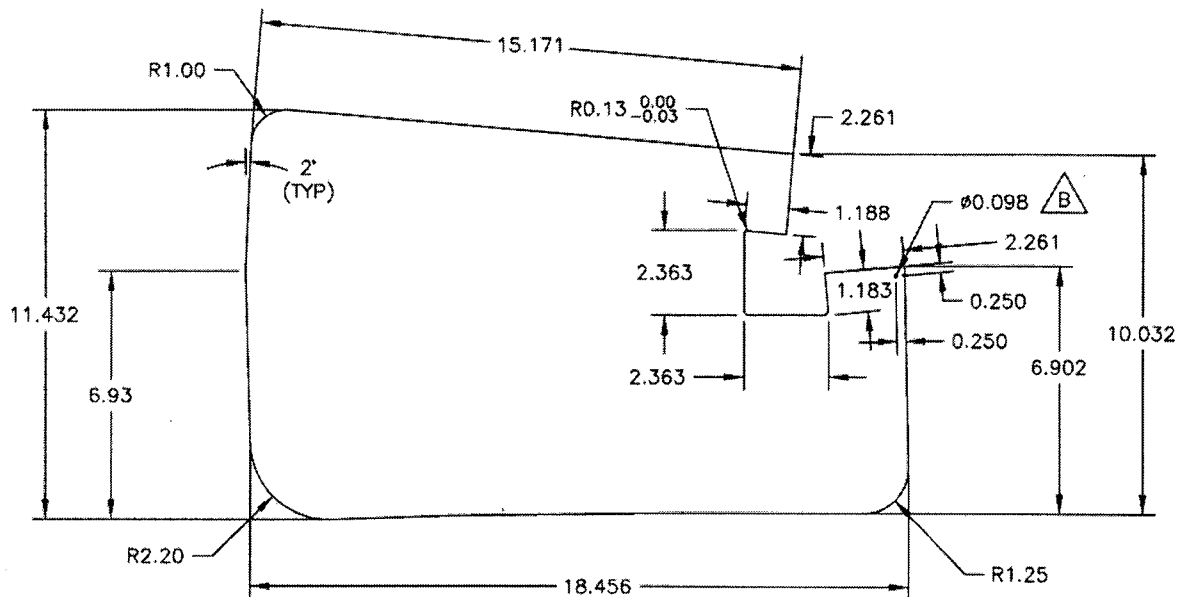
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DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED
05-01-18 [Signature]



D3255-1/-2 FLAT PATTERN

#71634

D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

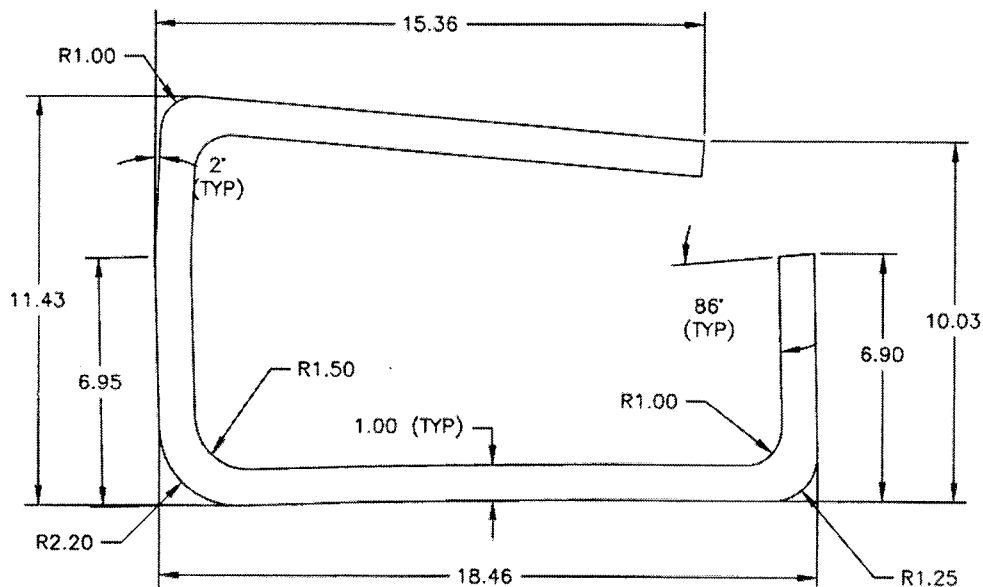
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DESIGN JF	DRAWN BY JF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED JF	DRAWING NO. D3255	REV. B SHEET 4 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED
05 01.18 #



D3255-5 GASKET

*71634

D3255-5 NOTES:

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F
P/N SIL/F 36x36x1/16
POSSIBLE SUPPLIER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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